

Date: Wednesday, 17/12/2008 1:52:50 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : UPPER DOUBLER
Job Number : 44150	
Estimate Number : 12809	
P.O. Number :	Part Number : D36083
This Issue : 17/12/2008 S.O. No. :	Drawing Number : D3608 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 42611	Material :
Written By :	Due Date : 09/01/2009 Qty: <u>5</u> Um: Each
Checked & Approved By : <u>JUD 08-12-17</u>	
Comment : Est Rev:A New Issue 07-03-26 JLM Est Rev:B 08-10-15 preliminary issue DD verified by:EC Est Rev:C 08-12-11 rev.A as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.7762 sf(s)/Unit Total : 3.1046 sf(s)
 304/316 .040 Sheet
 Batch: 110076 B 9-1-7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3608
 Dwg Rev: A B 9-1-7
 Prog Rev: A

5

2-Deburr if necessary B 9-1-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-1-7

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 0910107 (X5)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Deburr if necessary
 2- Bend as per Dwg D3608

5 08 101/08

P70

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3608-3 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (A) Date: 02/01/13
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44150</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/01/08</u>	<u>5</u>	<u>1 part is scrap</u> <u>and 2 measure are</u> <u>out of tolerance at</u> <u>the set-up</u> <u>R.C. first time</u> <u>in production</u>	<u>[Signature]</u> <u>QMR</u>	<u>scrap & destroy</u> <u>part is acceptable</u>	<u>[Signature]</u> <u>08/01/08</u> <u>QMR</u>	<u>09/01/09</u>	<u>[Signature]</u> <u>QMR</u>	<u>[Signature]</u> <u>QMR</u>

NOTE: Date & initial all entries

Date: Wednesday, 17/12/2008 1:52:50 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER DOUBLER

Job Number: 44150

Part Number: D36083

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/01/09 (75)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPD. 44146

JS 09/01/12 (X5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/12 JG

Job Completion



msr Kie

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 44150
Description: UPPER DOUBLER	Part Number: D3608-3
Inspection Dwg: D3608-3, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	X			
.500	± .010	.498	X			
1.820	± .010	1.813	X			
7.950	± .010	7.944	X			
11.50	± .030	11.48	X			
2.25	± .030	2.263	X			
2.28	± .030	2.30	X			
2.000	± .010	1.998	X			
1.325	± .010	1.318	X			
3.750	± .010	3.749	X			
1.250	± .010	1.254	X			
8.50	± .030	8.491	X			
11.63	± .030	11.624	X			
7.008	± .010	7.004	X			
6.940	± .010	6.940	X			
2.46	± .030	2.462	X			
2.282	± .010	2.284	X			
1.406	± .010	1.412	X			
8.56	± .030	8.553	X			

Measured by: HB
Date: 9-1-7

Audited by: S
Date: 09/01/07

Prototype Approval: A
Date: 11

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8

7

6

5

4

3

2

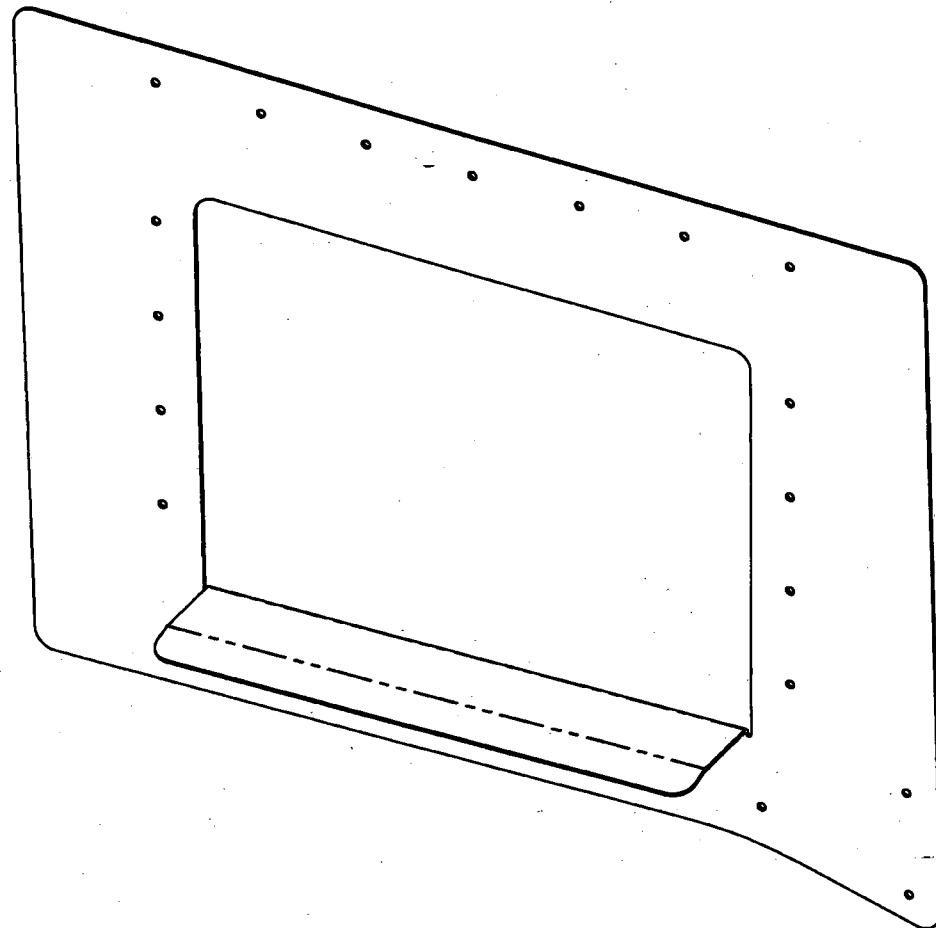
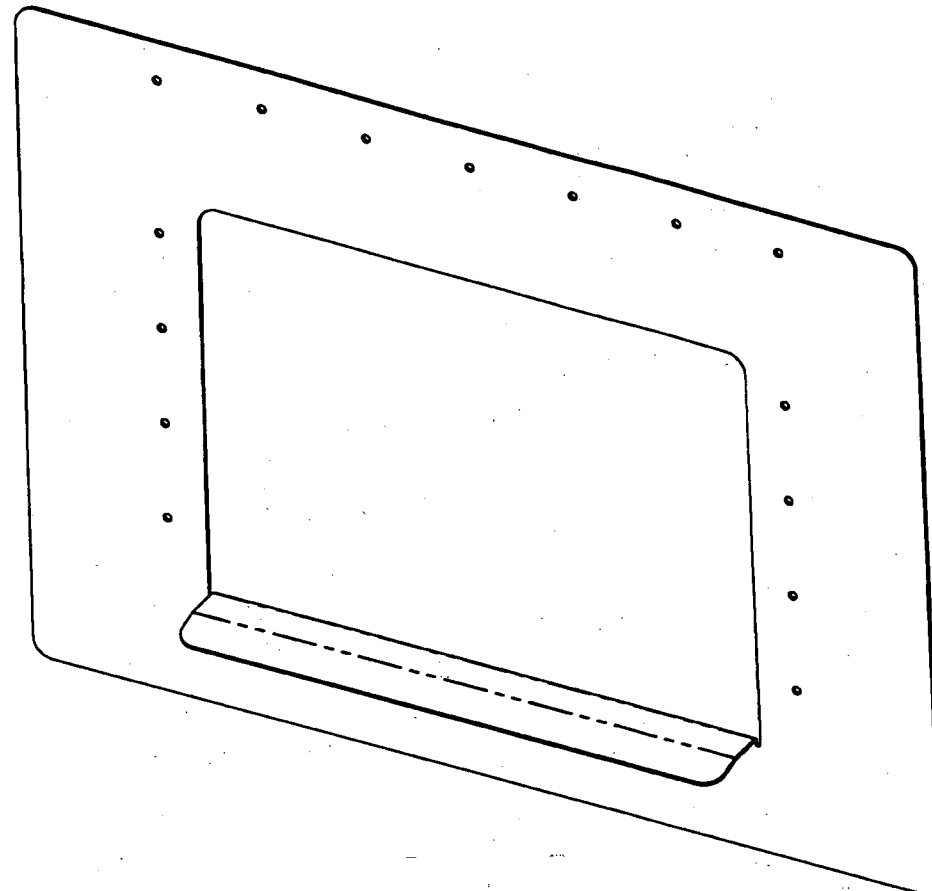
1

D

C

B

A

**D3608-1 LOWER DOUBLER****D3608-3 UPPER DOUBLER**

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WITHOUT NOTICE
WORK ORDER
NO. 44150

RELEASED
08/12/10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs EACH

A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.11		

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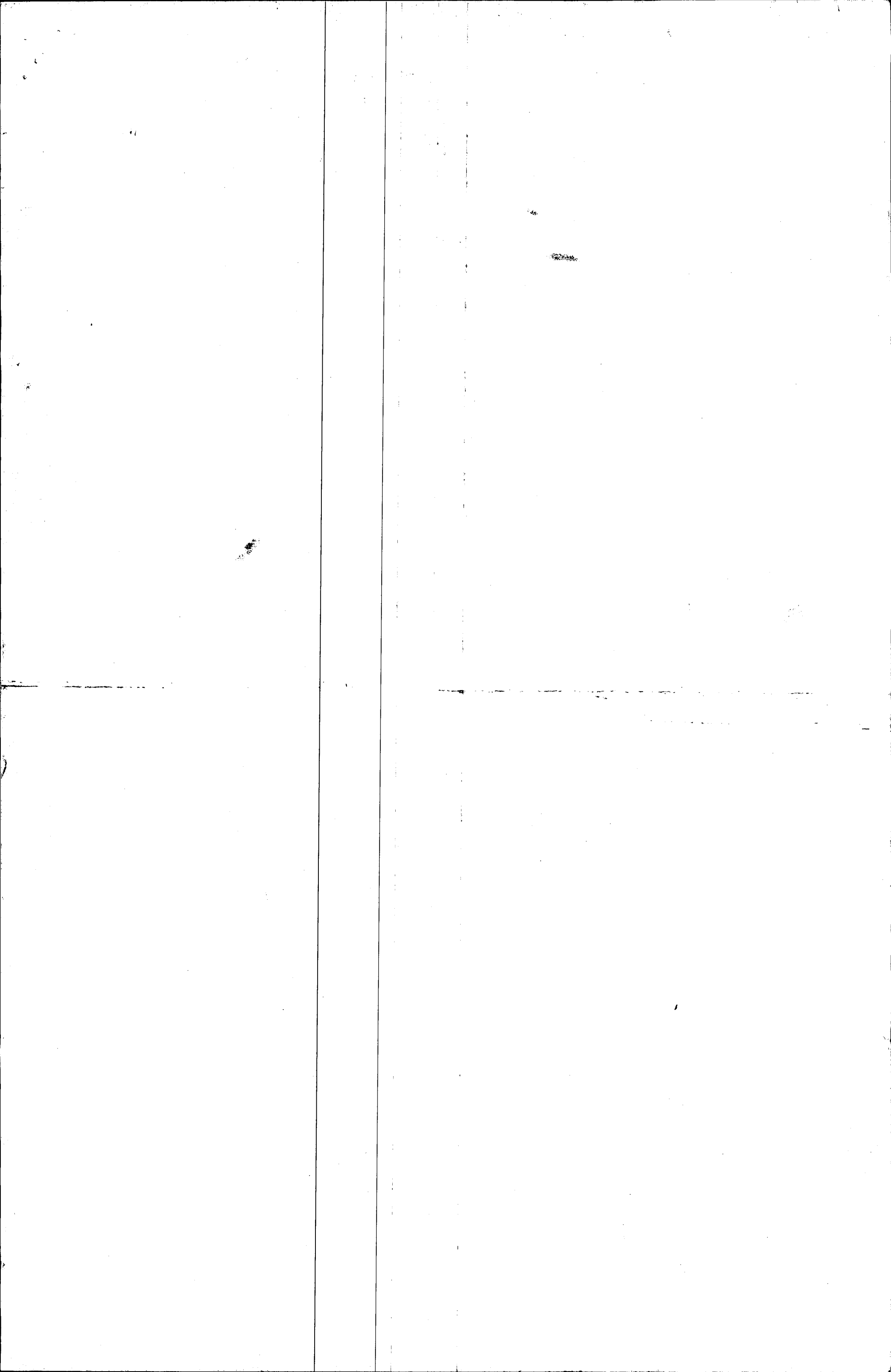
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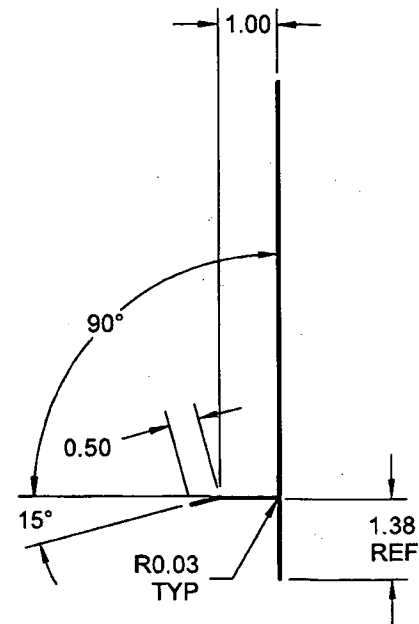
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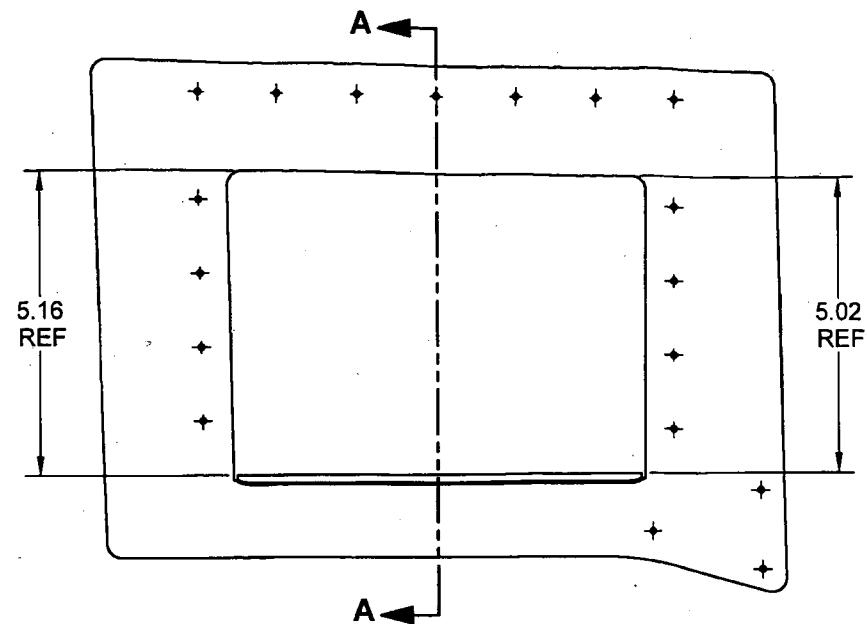
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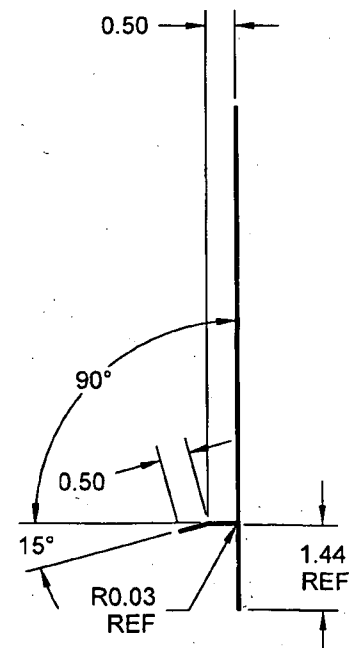




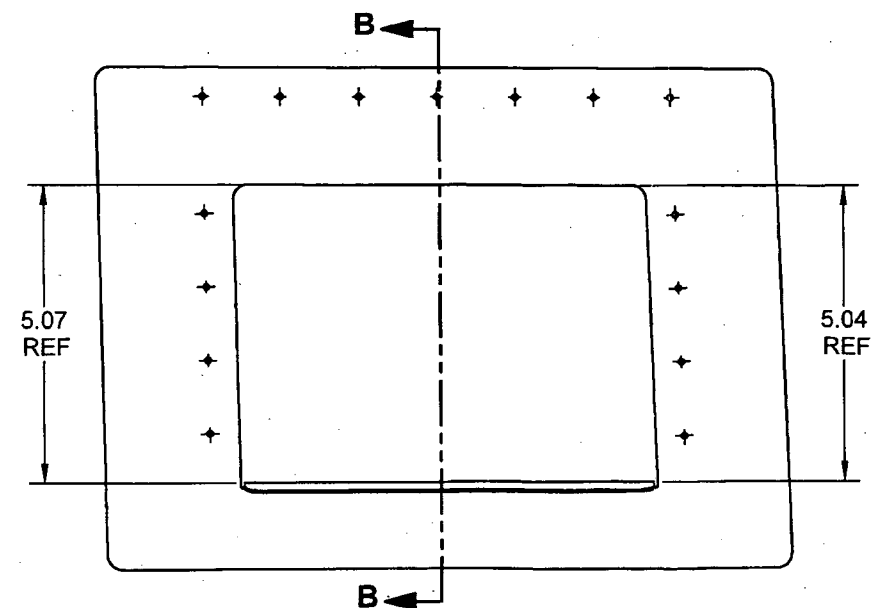
SECTION A-A



D3608-1 LOWER DOUBLER
(MAKE FROM D3608-1F)









SECTION B-B

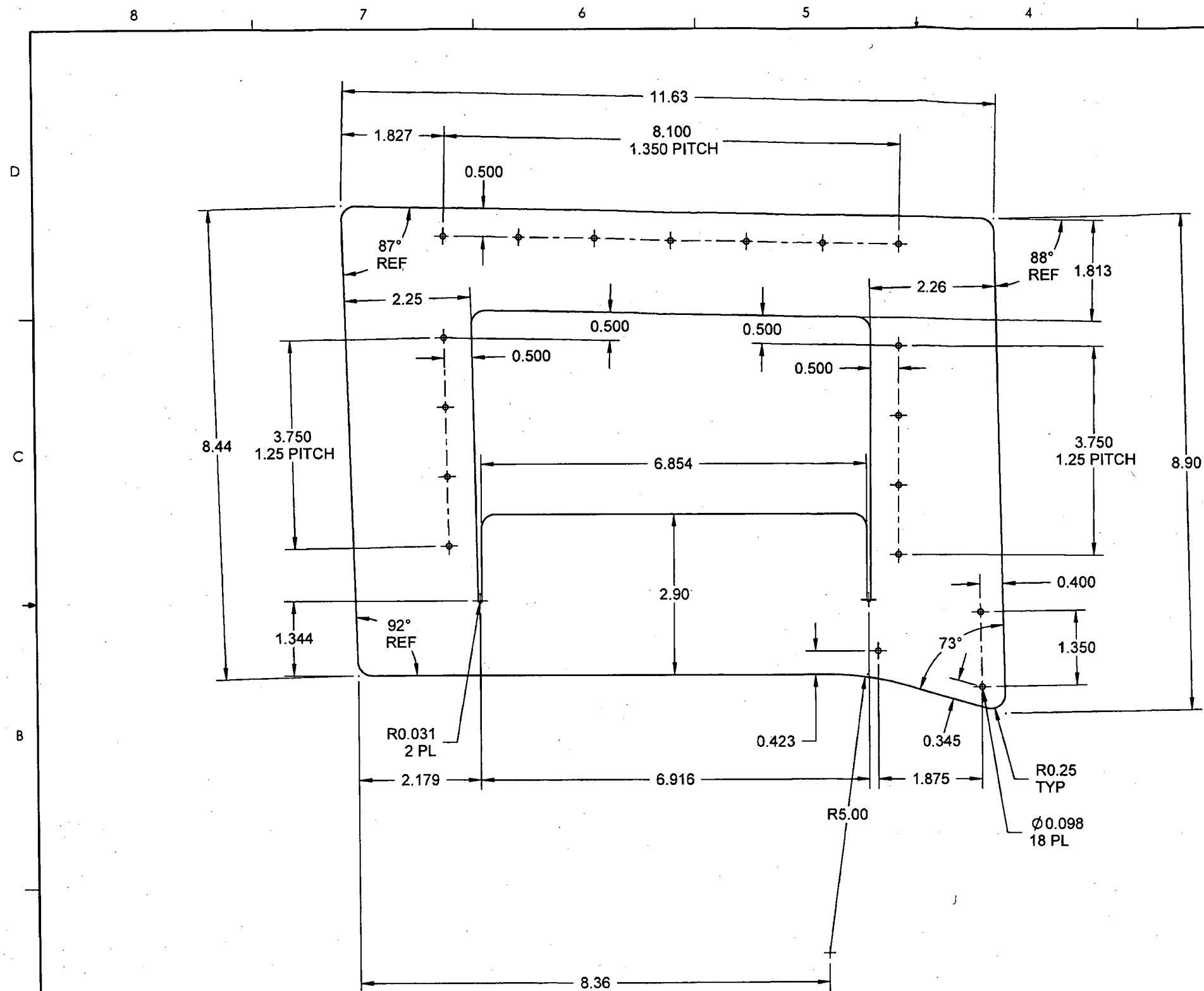


D3608-3 UPPER DOUBLER
(MAKE FROM D3608-3F)

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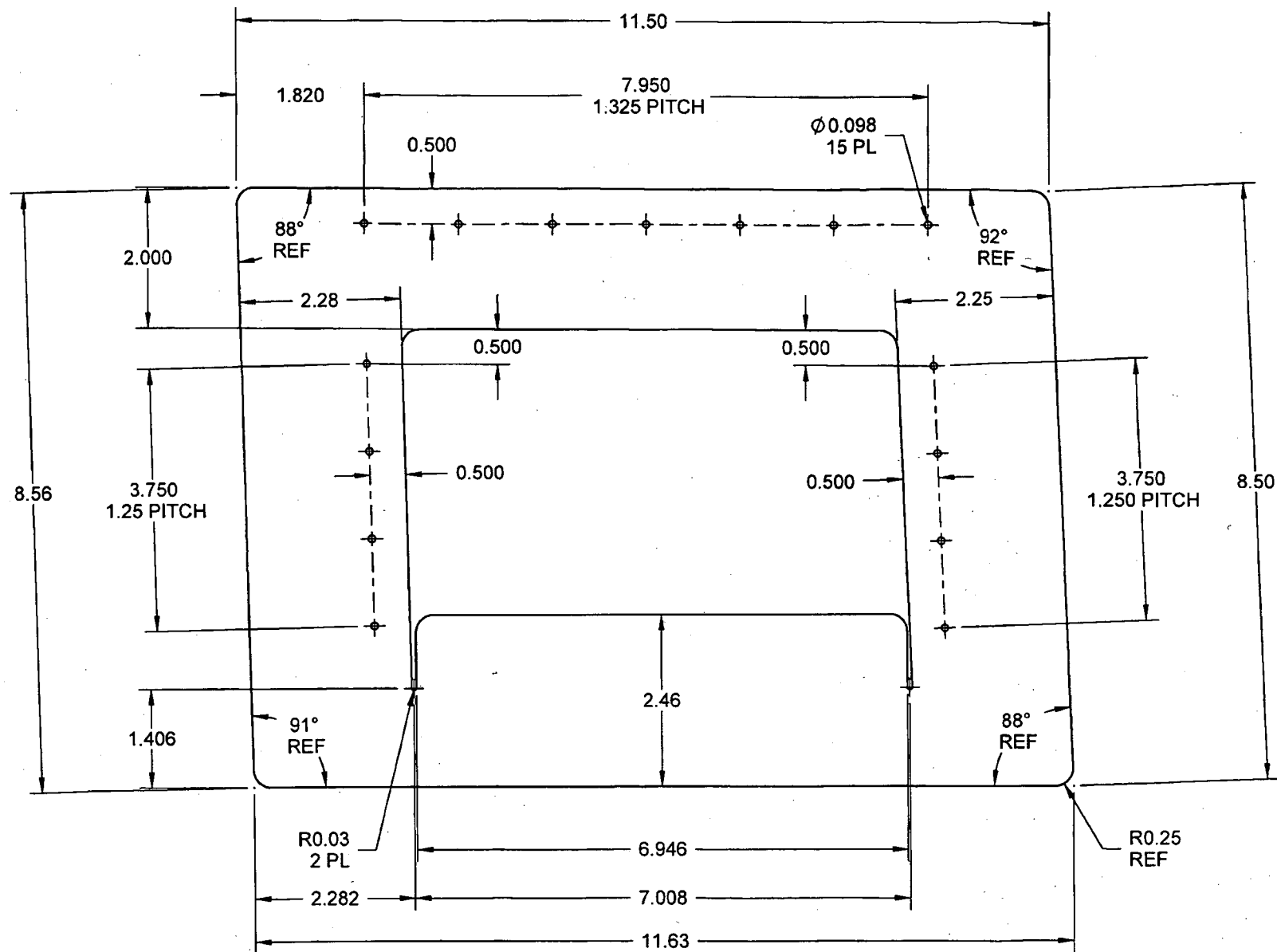


D3608-1F LOWER DOUBLER

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